

Work Order ID 59356 - 2

Wednesday, June 02, 2010 11:37:48 AM



MUST SHIP TODAY

Page 1

Item ID: D4127-1

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 6/2/2010 Start Qty: 4.00

Required Date: 6/2/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *MP*

Date: 10-6-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4127

A

100

0.00



Waterjet

Memo

0.00

Cut as per Dwg

DWG REV: *A*

PROG REV: *A*

DEBURR IF REQUIRED

10-6-2

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Mill Conv

0.00

Conventional Milling Machine

Memo

MILL RADS, DRILL HOLES AS PER DWG
GRIND RAD .060"-1.00" BY HAND

0.00

SA 10/06/02

5
X

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SA 10/06/02

5
X

150



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

SA 10/06/02

1

W/O:		WORK ORDER CHANGES						
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 59356

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Item ID: D4127-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Lug					
Start Date: 6/2/2010	Start Qty: 4.00		Cust Item ID:		
Required Date: 6/2/2010	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	all	10/06/03		5	✓		
170 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11/14/207 Memo Start: 2:30pm Temp: 320°F Fid 3:00pm	0.00 0.00	all	10/06/03		5	✓		
180 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5	✓	10-6-3	

W/O:		WORK ORDER CHANGES						
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Page 4

Item ID: D4127-1	Accept		Setup Start	
Revision ID:			Stop	
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Start Date: 6/2/2010	Start Qty: 4.00		Cust Item ID:	
Required Date: 6/2/2010	Req'd Qty: 4.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <i>ST</i>	0.00							
	Memo <i>459</i>	0.00		<i>= 7 m. h</i>	<i>10/06/04</i>	<i>(SX)</i>			
Packaging									
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							
QC									
Quality Control									

10/06/04
ME
10-6-4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 02, 2010 11:37:48 AM

Page 1

Work Order ID: 59356



Parent Item: D4127-1



Parent Item Name: Lug

Start Date: 6/2/2010

Required Date: 6/2/2010

Comments: IPP REV:A NEW ISSUE 10-05-28 JLM VERIFIED BY:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No				f	44.0800	0.35	1.473684	2,		



6061T6 BAR .750 X 6.00



HB 10-6-0

Location

Loc Qty

Loc Code

MAT03

44.08

112567

44.08

112567

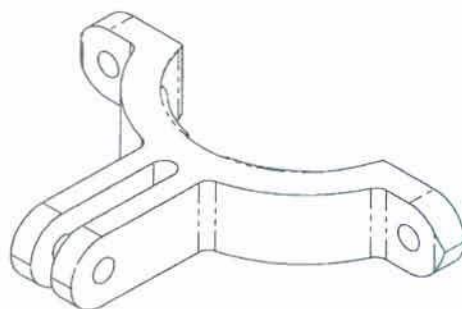
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4127-1 LUG

59356

RELEASED
2010-05-28
NW

A	NEW ISSUE	MB	10.05.26
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.26		

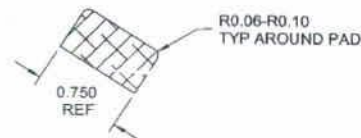
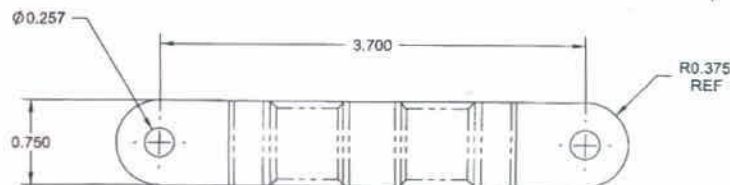
W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

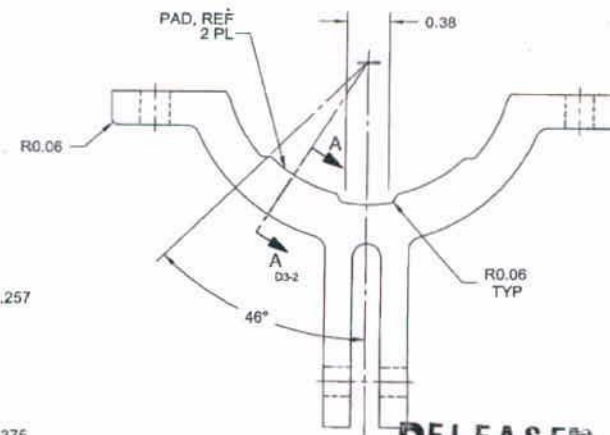
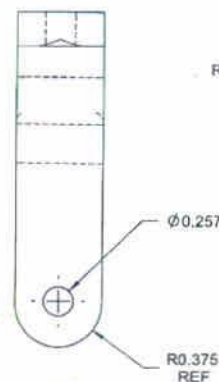
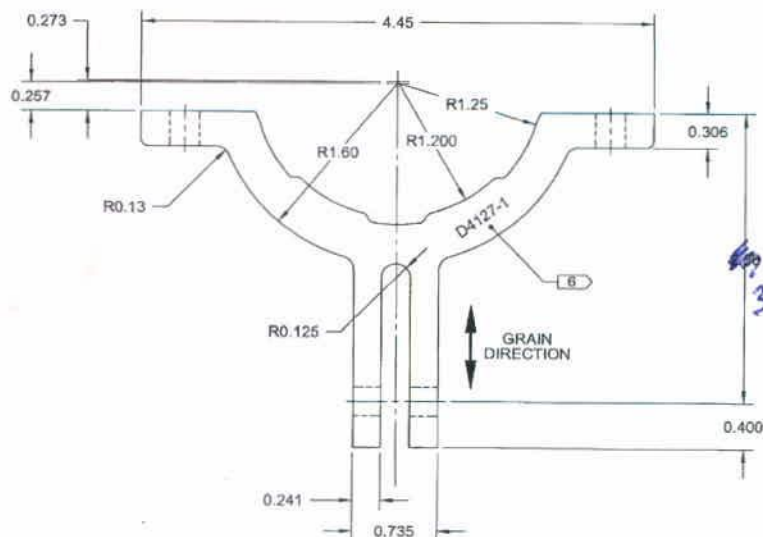
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



SECTION A-A
SCALE 1X

#59356



D4127-1 LUG

RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, BAR, OR EXTRUSION
PER QQ-A-200/8, QQ-A-225/8, QQ-A-250/8, ASTM B209, ASTM B211, OR ASTM B221
(REF DART SPEC. M6061T6B, M6061T6S)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.19 lbs

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MFG. APPR.			D4127	SHEET 2 OF 2
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